

Date: Wednesday, 7/5/2006 3:11:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 EXTRUSION BENDING
 Job Number : 27831
 Estimate Number : 10311
 P.O. Number : NIA Part Number : D2620
 This Issue : 7/5/2006 S.O. No. : NIA Drawing Number : D2620 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : MA Type : LANDING GEAR Drawing Revision : B
 Previous Run : 27205 Material : NIA
 Written By : SEE COMMENT BELOW Due Date : 7/30/2006 Qty: 20 Um: Each
 Checked & Approved By : 06-07-05
 Comment : Est. D 02-07-26 Change Dwg to rev.B; Updated Location RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	B24508

DP 6-7-7

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

Pm 06-07-7 (30)

DP 6-7-7

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-07-10 (30)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 06-07-10 (30)

5.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Inspection Level 21

DP 06-07-11

11 06-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

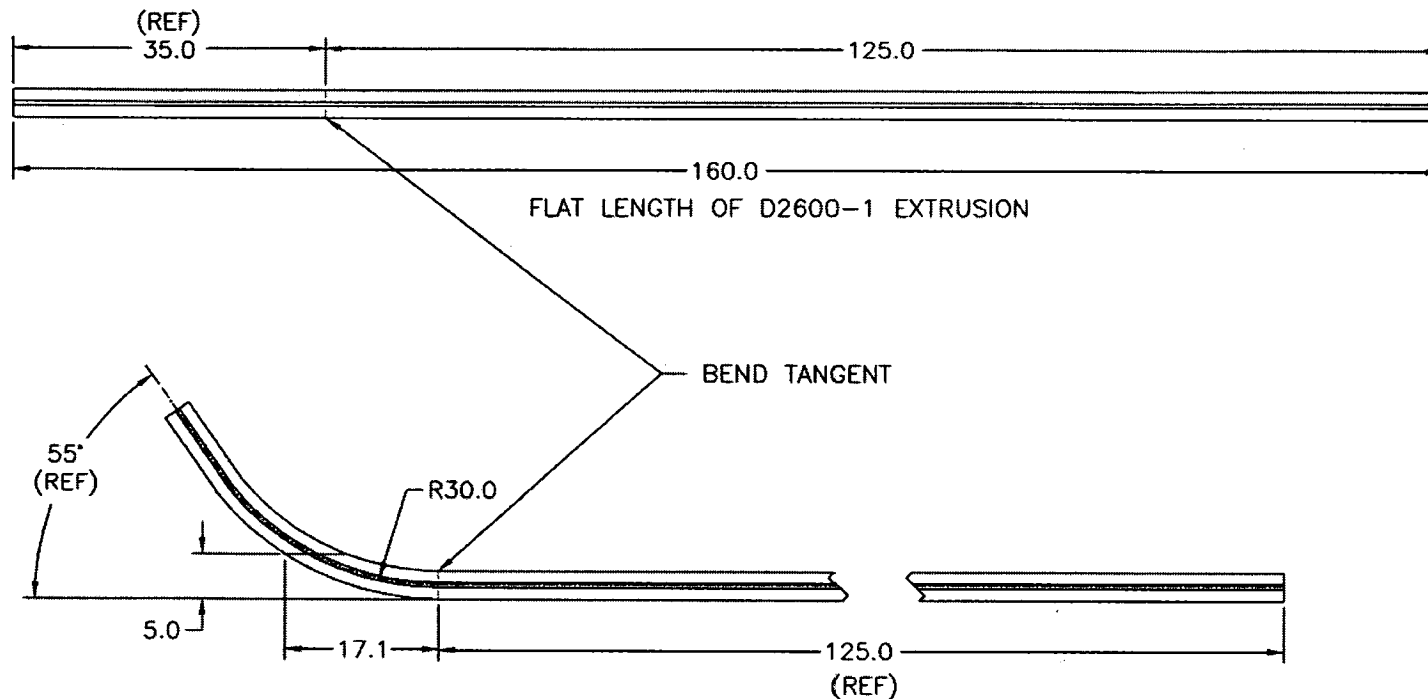
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	RF	APPROVED	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	TITLE	206 SKIDTUBE BENDING CONTROL	REV. B
A	97.11.07	NEW ISSUE		SHEET 1 OF 1
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		SCALE 1:20

RELEASED
49.04.15 DS

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